

Date: Monday, 27/04/2009 12:53:03 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE KIT FOR D206-642-511
Job Number : 47542	
Estimate Number : 12893	
P.O. Number :	Part Number : K642 511
This Issue : 27/04/2009 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : N/A
Previous Run : 47028	Material :
Written By :	Due Date : 10/05/2009 Qty: 2 Um: Each
Checked & Approved By : <u>JD 09.04.27</u>	
Comment : Est Rev.A 07.06.05 new issue EC Est Rev.B 08.02.05 , Per ECN1080P LL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JD 09/05/13
Comment: DOCUMENT CONTROL

Create White labels per PPP K642-511 CHG003
8 09/05/13

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D206648013	GHW Modification
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CHG002
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GHW Kit

Batch: 46635

4.0	D2652	Bushing
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**Comment:** Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2652

Bushing

B46608

5.0	D2712	Set Screw
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**Comment:** Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

10 D2712

Set Screw

B45247

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0 D29321 Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2932-1 Saddle 45262

8809105/13 (2)

7.0 D29331 Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2933-1 Saddle 42976

8809105/13 (2)

8.0 D2934 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2934 Saddle Spacer 44296

8809105/13 (2)

9.0 D2935 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2935 Saddle Spacer 44553

8809105/13 (2)

10.0 D29381 Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2938-1 Saddle 44554

8809105/13 (2)

11.0 D29391 Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2939-1 Saddle B47115 RevC

8809105/13 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D33963

Spacer

X



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3396-3

Spacer

B345667

SS 09/05/13 (X2)

13.0

D3407043

Tow Ring

X



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-043

Tow Ring

44578

SS 09/05/13 (X2)

14.0

D34561

Washer

X



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

Washer

B346752

SS 09/05/13 (X2)

15.0

D34571

Washer

X



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3457-1

Washer

44793

SS 09/05/13 (X2)

16.0

AN3C35A

BOLT

X



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C35A

Bolt

M109323

SS 09/05/13 (X2)

17.0

AN3C36A

BOLT

X



Comment: Qty.: 9.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

9 AN3C36A

Bolt

M109771

SS 09/05/13 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN3C41A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M108409

SS09105/13 (X1)

19.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M111295

SS09105/13 (X1)

20.0

AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M109898 X15 M110847 X1

SS09105/13 (X1)

21.0

AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M167328

SS09105/13 (X2)

22.0

AN5C13A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M167800

SS09105/13 (X2)

23.0

AN5C15A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M169148

SS09105/13 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 47542

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M67463

8809105/13 @

25.0

AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M110342

8809105/13 @

26.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M107551

8809105/13 @

27.0

AN960C10L

washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M111608

8809105/13 @

28.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

M111359

8809105/13 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 47542

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C516L

Washer

M16139 K3
M109545 x13

SS 09/05/13 (K2)

30.0

MS210433

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS21043-3

Nut

M111383

SS 09/05/13 (K2)

31.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

13 MS21043-4

Nut

M111274 x20
M111295 x6

SS 09/05/13 (K2)

32.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 MS21043-5Nut

M110180

SS 09/05/13 (K2)

33.0

D36721

Phenolic Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

PHENOLIC WASHER

47628

SS 09/05/13 (K2)

34.0

D36723

Phenolic Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

PHENOLIC WASHER

47623

SS 09/05/13 (K2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 47542

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D36725

Phenolic Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s)
PHENOLIC WASHER

B44679

SS 09/05/13 (X2)

36.0

D36727

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)
PHENOLIC WASHER

B35522

SS 09/05/13 (X2)

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/05/13 (X2)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-511 CHG003

Location: _____

1x PPP47585

1x FG PG.

SS 09/05/14 (X2)

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/14

Job Completion



mf 09-05-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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